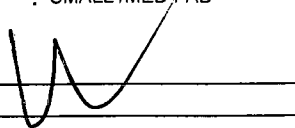


Date: Wednesday, 23/04/2008 7:26:54 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: DOUBLER
<b>Job Number</b>	: 38739		
<b>Estimate Number</b>	: 11645		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D29921
<b>This Issue</b>	: 23/04/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2992 REV A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 38743	<b>Drawing Revision</b>	: A
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	: 	<b>Due Date</b>	: 30/04/2008
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	6
<b>Comment</b>	: Est B 02.03.06 Added dwg Rev.B NG	<b>Um:</b>	Each
	Est Rev:C 08-04-22 now on water jet DD verified by:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M5052H32S040	5052-H32 .040 Sheet
-----	--------------	---------------------



**Comment:** Qty.: 0.0802 sf(s)/Unit Total: 0.4813 sf(s) **1.5 SF**  
 5052-H32 .040 Sheet  
 Material: 5052-H32 0.040" sheet  
 Batch: **17835 IB 8-4-24**

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D2992 **IB 8-4-24**  
 Dwg Rev: **A**  
 Prog Rev: **A**

2-Deburr if necessary

**08/04/24****83****(14)****(14)**

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE**IB 8-4-24**

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK**08/04/24 (14)**

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

**FL 08/04/24 (14)**

Date: Wednesday, 23/04/2008 7:26:54 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 38739

Part Number: D29921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER.COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BR 08-04-24*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *558*

*ch 7421*

*Re 5/4/24 (14)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/04/29*

Job Completion



*MF 08-04-28*

Date: Tuesday, 4/22/2008 3:11:02 PM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOUBLER
<b>Job Number</b> :	38739		
<b>Estimate Number</b> :	11645		
<b>P.O. Number</b> :		<b>Part Number</b> :	D29921
<b>This Issue</b> :	4/22/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2992 REV A
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	25941	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	4/24/2008
<b>Written By</b> :		<b>Qty:</b>	6
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est B 02.03.06 Added dwg Rev.B NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M5052H32S040	5052-H32 .040 Sheet
-----	--------------	---------------------



**Comment:** Qty.: 0.0802 sf(s)/Unit Total : 0.4813 sf(s)  
 5052-H32 .040 Sheet  
 Material: 5052-H32 0.040" sheet  
 Batch: \_\_\_\_\_

2.0	SHEAR	SHEAR
-----	-------	-------



**Comment:** SHEAR  
 Make as per dwg D2992  
 Deburr

*waterjet*

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



**Comment:** INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per CSI 005 4.1

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: \_\_\_\_\_

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/22/2008 3:11:02 PM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 38739

Part Number: D29921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

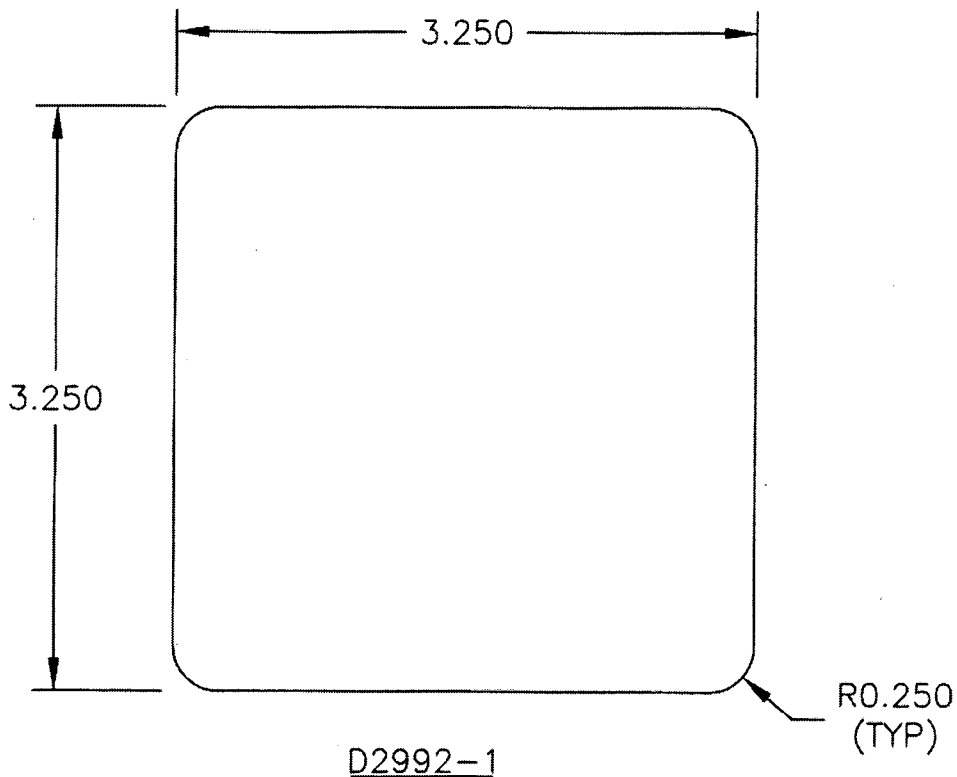
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2992	REV. A SHEET 1 OF 1
DATE 02.01.21		TITLE DOUBLER	SCALE 1:1
A	02.01.21	NEW ISSUE	

RELEASED  
02.01.25 *[Signature]*



NOTES:

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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C208/04/22  
W10:38739

